



PRODUCT PROFILE

GENERIC DESCRIPTION	Modified Polyamidoamine Epoxy
COMMON USAGE	High-build coating with superior wetting for marginally prepared rusty steel and tightly adhering old coatings. Excellent abrasion-, chemical- and corrosion-resistance. Perfect foundation for aliphatic-polyurethanes. NOT FOR IMMERSION SERVICE.
COLORS	DC74 Off-White, 1243 Metallic Aluminum and more: refer to Tnemec Color Guide. Note: Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, miscatalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may cause yellowing to occur.
FINISH	Semi-gloss
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS	Steel: Self-priming Galvanized Steel and Non-Ferrous Metal: Self-priming
TOPCOATS	Series 6, 30, 35, 66, L69, L69F, N69, N69F, V69, V69F, 73, 84, 104, 115, 161, 1028, 1029, 1070, 1071, 1072, 1074, 1074U, 1075, 1075U. Note: When topcoating with Endura-Shield polyurethane finish, exterior exposed Series 135 has the following maximum time to recoat: Series 73, 1074/1074U or 1075/1075U, 60 days. Series 1070, 1071 or 1072, 14 days. If these times are exceeded, an epoxy intermediate coat or scarification is required before topcoating. Refer to appropriate topcoat data sheet for additional information.

SURFACE PREPARATION

STEEL	Abrasive blast cleaning to SSPC-SP6/NACE 3 generally produces the best coating performance. If conditions will not permit this, Series 135 may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces.
GALVANIZED STEEL & NON-FERROUS METAL	Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.
PAINTED SURFACES	Test patch is recommended.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	84.0 ± 2.0% (mixed) †
RECOMMENDED DFT	Conventional Build: 4.0 to 6.0 mils (100 to 150 microns) per coat. Hi-Build: 7.0 to 9.0 mils (180 to 230 microns) per coat. Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75°F (24°C)	6 hours at 5.0 mils DFT (125 microns)	18 hours	24 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS

EPA Method 24 **Unthinned:** 0.72 lbs/gallon (86 grams/litre)
Thinned 15% (No. 19 Thinner): 1.91 lbs/gallon (229 grams/litre)
Thinned 15% (No. 18 Thinner): 2.05 lbs/gallon (246 grams/litre)
Thinned 15% (No. 62 Thinner): 0.72 lbs/gallon (86 grams/litre) †

HAPS

Unthinned: 1.29 lbs/gal solids
Thinned 15% (No. 19 Thinner): 2.54 lbs/gal solids
Thinned 15% (No. 18 Thinner): 1.29 lbs/gal solids

THEORETICAL COVERAGE

1,347 mil sq ft/gal (33.1 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS

Two: Part A and Part B

MIXING RATIO

By volume: Four (Part A) to one (Part B)

PACKAGING

Five-Gallon Kit: Consists of four gallons of Part A in a five-gallon pail and one gallon of Part B in a one-gallon can. When mixed, yields five gallons (18.9L).
One-Gallon Kit: Consists of a partially filled one-gallon can of Part A and a partially filled one-quart can of Part B. When mixed, yields one gallon (3.79L).

NET WEIGHT PER GALLON

Series 135: 12.30 ± 0.25 lbs (5.58 ± .11 kg) (mixed)
135-1243: 11.52 ± 0.25 lbs (5.23 ± .11 kg) (mixed) †

STORAGE TEMPERATURE

Minimum 20°F (-7°C) Maximum 120°F (49°C)

TEMPERATURE RESISTANCE

(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

SHELF LIFE

24 months at recommended storage temperature.

FLASH POINT - SETA

Part A: 75°F (25°C) Part B: 201°F (94°C)

HEALTH & SAFETY

Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

CHEMBUILD® | SERIES 135

APPLICATION

COVERAGE RATES

Conventional Build (Spray, Brush or Roller)

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	5.0 (125)	6.0 (150)	269 (25.0)
Minimum	4.0 (100)	5.0 (125)	337 (31.3)
Maximum	6.0 (150)	7.0 (180)	224 (20.8)

High-Build (Spray Only)

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	8.0 (205)	9.5 (240)	168 (15.6)
Minimum	7.0 (180)	8.5 (215)	192 (17.8)
Maximum	9.0 (230)	11.0 (280)	150 (13.9)

Note: Can be spray applied at 7.0 to 9.0 mils (180 to 230 microns) DFT per coat when extra protection or the elimination of a coat is desired. Can be sprayed at 4.0 to 6.0 mils (100 to 150 microns) DFT per coat for use in systems requiring a conventional build. Brush or roller will normally achieve the 4.0 mil (100 microns) minimum for conventional build application. However, under certain conditions some colors may require two coats to achieve suggested film thickness. Allow for overspray and surface irregularities. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

MIXING

Power mix contents of each container, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. **Note:** Both components must be above 50°F (10°C) prior to mixing. For application to surfaces between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C).

THINNING

For air or airless spray, thin 10% to 15% or 3/4 pint to 1 1/4 pints (380 to 570 mL) per gallon with No. 19 or No. 62 Thinner. For brush or roller, thin 10% to 15% or 3/4 pint to 1 1/4 pints (380 to 570 mL) per gallon with No. 18 or No. 62 Thinner.

POT LIFE

8 hours at 50°F (10°C) 4 hours at 77°F (25°C) 2 hours at 100°F (38°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E .070"	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	70-90 psi (4.8-6.2 bar)	20-30 psi (1.4-2.1 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.021" (430-535 microns)	3000-4200 psi (207-290 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Note: Series 135-1243 must be applied by brush or roller to achieve aluminum appearance. For spray application, contact your Tnemec representative.

Roller: Use 3/8" or 1/2" (9.5 mm or 12.7 mm) synthetic woven nap covers.

Brush: Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 50°F (10°C) Maximum 135°F (57°C)

The surface should be dry and at least 5°F (3°C) above the dew point. **Note:** Amine blush may develop during cure if the surface temperature drops below the minimum, particularly under high humidity. Blush must be removed prior to topcoating; contact your Tnemec representative.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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